

Work Order ID 52676

October 7, 2009 8:11:07 AM



Page 1

Item ID: D2282-043

Accept



Setup Start



Revision ID: E

Stop



Item Name: Saddle Assembly

Start Date: 10/09/09 Start Qty: 50.00



Cust Item ID:

Required Date: 10/16/09 Req'd Qty: 50.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D2282	Rev E
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100	0.00
-----	------

	Large Fab
--	-----------

Large Fab	0.00
-----------	------

Large Fab	Memo
-----------	------

I-Weld as per D2282-043 Saddle Assembly A/RER316L SS
Rod M108775 Filling
Dwg Rev: E

110	0.00
-----	------

	Small Fab
--	-----------

Small Fab	0.00
-----------	------

Small Fab	Memo
-----------	------

1- grind weld flush, take all welding marks out and deburr holes

120	0.00
-----	------

	QC9- Inspect visual per QSI004- Fusion Welds
--	--

QC	0.00
----	------

Quality Control	Memo
-----------------	------

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 52676

October 7, 2009 8:11:07 AM



Page 2

Item ID: D2282-043

Accept



Setup Start



Revision ID: E

Stop



Item Name: Saddle Assembly

Start Date: 10/09/09 Start Qty: 50.00



Cust Item ID:

Required Date: 10/16/09 Req'd Qty: 50.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



QC5- Inspect part completeness to step on W/O

0.00

58
as 10/10

QC

Memo

0.00

Quality Control

140



Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

I-tumble

KB 9-11-11

150



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

58
cont'd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 52676

October 7, 2009 8:11:08 AM



Page 3

Item ID: D2282-043

Accept



Setup Start



Revision ID: E

Stop



Item Name: Saddle Assembly

Start Date: 10/09/09 Start Qty: 50.00



Cust Item ID:

Required Date: 10/16/09 Req'd Qty: 50.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

160

Identify as per dwg & Stock Location: 261



Packaging

Memo

Packaging

Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
0.00	45x	6-A	CB 09/11/12	91/11/12	56	38x	
0.00							

170

QC21- Final Inspection - Work Order Release

0.00



QC

Quality Control

Memo

0.00

09/11/13 HJ

MF
09-11-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

October 7, 2009 8:11:06 AM

Work Order ID: 52676



Parent Item: D2282-043RevE



Parent Item Name: Saddle Assembly

Start Date: 10/09/09

Required Date: 10/16/09

Comments:

Start Qty: 50.00

Required Qty: 50.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2281RevG 		Manufactured	No		52899	100	Each	0.0000	50.0000		Sp 09.10.28	
Jack Saddle 		Manufactured	No			100	Each	34.0000	100.0000			
D2282-7RevE 												

Tube

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	34	
48283	34	

B 52897

103 X

Sp 09.10.28.

103 X

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

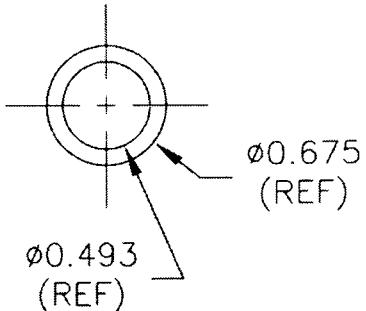
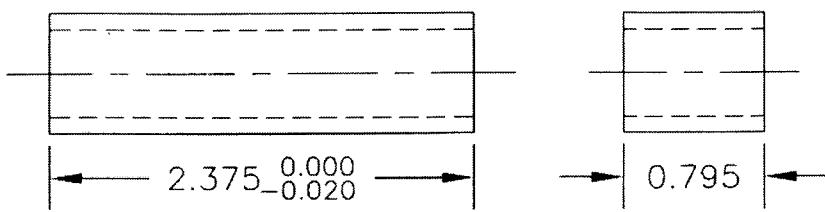
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

4/26/16 **DART**

DESIGN BW	DRAWN BY <i>FZ</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>IP</i>	APPROVED <i>DP</i>	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07	TITLE HANDLE TUBES		SCALE 1:1
A	94.10.14	NEW ISSUE	
B	95.03.23	RE-DESIGN	
C	97.10.20	CORRECTED NUMBERING SCHEME	
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750	
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030	

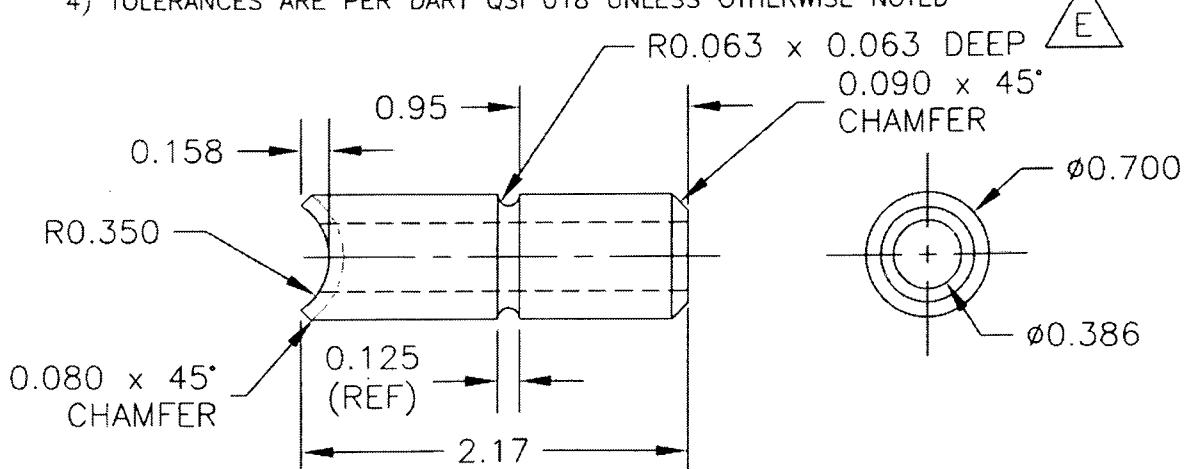


D2282-3

D2282-7

D2282-3/-7 TUBE:

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2282-5

D2282-5 STEM:

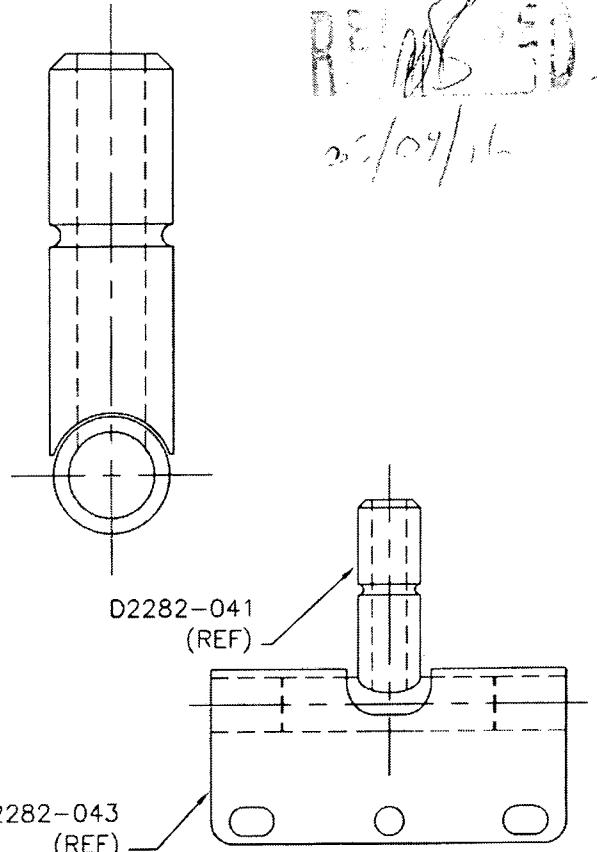
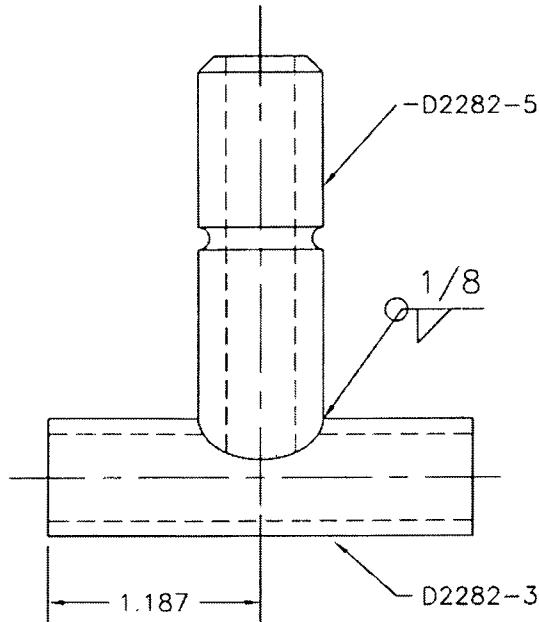
- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

E

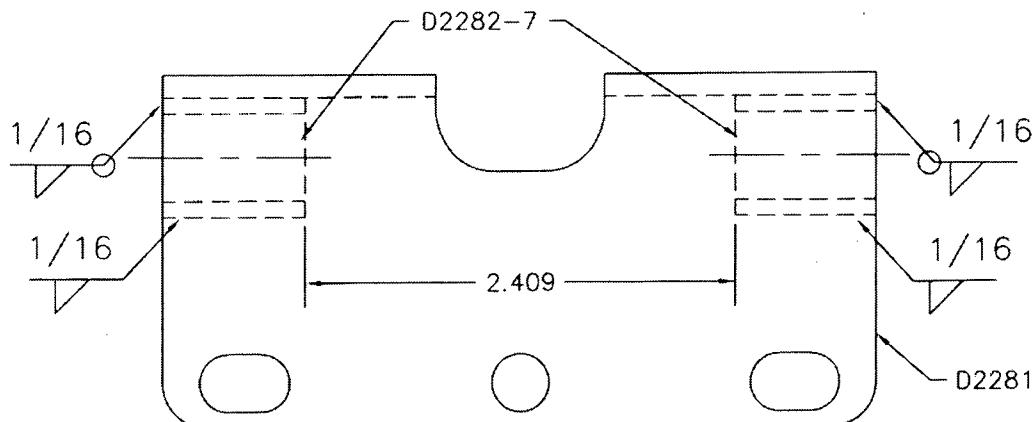
W0 52670

DART

DESIGN BW	DRAWN BY <i>FT</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>IP</i>	APPROVED <i>MC</i>	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1



D2282-041 'T' ASSEMBLY
WELD ASSEMBLY PER DART QSI 004



D2282-043 SADDLE ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

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